

Application No. 10/579,444
Amendment dated June 16, 2008
Reply to Office Action of March 27, 2008

Page 2

Amendments to the Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

1. (cancelled)
2. (cancelled)
3. (cancelled)
4. (cancelled)
5. (cancelled)
6. (cancelled)
7. (cancelled)
8. (cancelled)
9. (previously presented): A pipe molding system for producing plastic pipe, said system including
 - a plurality of moving first mold block sections and second moving mold block sections,
 - the first mold block sections closing with the second mold block sections to form a moving mold tunnel,
 - means for feeding molten plastic to the first and second mold blocks sections to form the plastic pipe, and
 - a cooling plug for setting the plastic pipe in the moving mold tunnel,

Application No. 10/579,444
Amendment dated June 16, 2008
Reply to Office Action of March 27, 2008

Page 3

the plastic pipe having a pipe wall with a first wall portion which travels over and is in contact with said cooling plug and a second wall portion which travels over and is spaced outwardly away from said cooling plug,

the first wall portion transferring heat directly to said cooling plug;

said system including a first temperature control to prevent excessive plug cooling as the first wall portion travels over the cooling plug,

said system including a second temperature control which operates to replace the first temperature control in preventing the excessive plug cooling as the second wall portion of the pipe wall travels over the cooling plug.

10. (original): The pipe molding system of claim 9 wherein said cooling plug is cooled by a supply of chilled water, said second temperature control comprising a water flow adjuster to reduce flow of the chilled water to the cooling plug when the second wall portion of the pipe wall travels over the cooling plug.

11. (original): The pipe molding system of claim 9 wherein said cooling plug is cooled by a supply of chilled water, the chilled water being at a first temperature as the first wall portion travels over the cooling plug, said second temperature control comprising a water temperature control which raises temperature of the chilled water above the first temperature as the second wall portion of the pipe wall travels over the cooling plug.

12. (original): The pipe molding system of claim 9 wherein said cooling plug is internally cooled by a supply of chilled water, said second temperature control comprising a heater externally of and directing heat onto said cooling plug when said second wall portion of said pipe travels over said cooling plug, said heater being inactive when said first wall portion of the internal wall of the pipe travels over the cooling plug.

13. (original): The pipe molding apparatus of claim 9 wherein said system includes means to produce vacuum at the cooling plug when the first wall portion travels over the cooling plug to assist in maintaining the first wall portion in contact with the cooling plug, the means to produce vacuum being turned off when said second

Application No. 10/579,444
Amendment dated June 16, 2008
Reply to Office Action of March 27, 2008

Page 4

temperature control is operated as the second wall portion of the internal wall of the pipe travels over the cooling plug.

14. (previously presented): The pipe molding system of claim 9 wherein said system includes means to produce a vacuum at the cooling plug and said cooling plug comprises first and second plug sections;

said first plug section being subjected to the vacuum and being temperature controlled only by the first temperature control of the heat of the first wall portion to prevent the excessive plug cooling as the first wall portion travels over the first plug section while, at the same time, the second plug section is free of the vacuum and is subjected only to the second temperature control to prevent the excessive plug cooling as the second wall portion of the internal wall of the pipe travels over the second plug section, and then as the pipe moves along the mold tunnel, said first plug section being free of vacuum and being temperature controlled only by the second temperature control to prevent the excessive plug cooling as the second wall portion of the internal wall of the pipe travels over the first plug section while, at the same time, the second plug section is subjected to the vacuum and is temperature controlled only by the first temperature control of the heat of the first wall portion as the first wall portion of the internal wall of the pipe travels over the second plug section.